

WORK INSTRUCTION		
Title: Replacement of Miscellaneous Parts Not Requiring Detailed Instructions		
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Approved for Use by: <u>Michael R. Brown</u> Effective Date: <u>July 2003</u>		
Applicable Drawings:		
<ul style="list-style-type: none"> X-106-500-SNP (Sheets 1-9) RH-TRU 72-B Packaging SARP Drawings 		
SARP Requirements:		
<ul style="list-style-type: none"> None. Spare parts will be replaced if damaged, or as needed. 		
Tools Required:		
<ul style="list-style-type: none"> Slotted screw driver Small grinder Stainless steel tube wire brush ($\frac{3}{4}$-in.) 		
Spare Parts Required:		
<ul style="list-style-type: none"> The spare parts are identified in the work instruction steps. All spare parts listed are controlled and shall be recorded on the Maintenance Record. 		
Materials Required:		
<ul style="list-style-type: none"> Denatured alcohol or equivalent Lint-free rags 		
Safety Requirements:		
<ul style="list-style-type: none"> Safety will be observed in accordance with site requirements. 		
Prerequisite Conditions:		
<ul style="list-style-type: none"> The parts listed in this work instruction have been removed and made accessible. 		
Instruction Steps:		
<ul style="list-style-type: none"> There is no requirement to replace components in the sequence shown here. The spare parts listed below shall be replaced with like-for-like components from the approved spare parts supply. The replacement of these parts shall be documented on the Maintenance Record. This instruction is not required to be attached to the Maintenance Record, but may be used as a checklist during performance of maintenance. 		

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<input type="checkbox"/> Impact Limiter Burn Out Plug (2078-400-15) PO#_____		
1.0 Tighten flush with flange ($\pm \frac{1}{8}$ -in.).		
<input type="checkbox"/> Impact Limiter Lift Lug Assembly (2078-400-16) PO#_____		
NOTE: The above listed parts require no detailed instructions for installation.		
<input type="checkbox"/> IV Lid Alignment Pin (2078-200-19) PO#_____		
<input type="checkbox"/> OC Lid Alignment Pin (2078-300-16) PO#_____		
1.0 Remove tack weld (or stake) from pin using a small grinder on the welds.		
2.0 Remove alignment pin by unscrewing counter clockwise (CCW)		
3.0 Clean threads in body using $\frac{3}{4}$ -in. tube brush. Wipe clean using alcohol and lint-free rags.		
4.0 Clean threads of pin using alcohol and lint-free rags.		
5.0 Install alignment pins (alignment shall match SAR drawing) by screwing in clockwise.		
6.0 Stake (or tack weld) alignment pin in two places. Welds shall be visually inspected in accordance with AWS D1.1. All welding procedures and personnel shall be qualified in accordance with ASME Code, Section IX.		
Verification Requirements:		
1.0 Spare parts used are listed on the Maintenance Record.		
2.0 Work performed is described on the Maintenance Record.		
3.0 Work Instruction is listed on the Maintenance Record.		